Work Order ID 112086

January-29-14 9:56:18 AM

112086

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, RH

Start Date: 30/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MA **Date:** M-Or-29 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D4635	E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAND FINISHING THERMOFORMING	0.00							
100						x1	____	____	DL
Thermoform	**Memo**	0.00							14/02/01
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							
105						x1	____	____	DL
HandThermo	**Memo**	0.00							14/02/01
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: 250° F								
	Time IN: 5:00 pm 14/01/31								
	Time OUT: 6:00 am 14/02/01								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft Ceiling Panel, RH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x1			DL
Thermoform	**Memo**	0.00							14/02/21
Thermoforming Machine	Thermoform as per Dwg. D4635-4 and Folio FTA150								
	Dwg. Rev. E								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					1			14/02/27
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC5 ~~QC6~~ Inspect dimensions to drawing	0.00	DAS 16 9-89						
140	Dimensional Inspection								
QC	**Memo**	0.00	14/03/14						
Quality Control	FIll out Inspection Sheet Rev A								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
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Offset/Setup	☐									
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Supplier	☐									
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Transport	☐									
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Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Aft Ceiling Panel, RH

Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150 QC Quality Control	**Memo** N/A S	0.00							
160	Packaging	0.00							
160 Packaging Packaging	**Memo** meal Fab	0.00				①	SAD	14/03/14	
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00				MCJ	14-03-14		

ME 14-3-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Use-as-is ☐
Suspected Unapproved ☐

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

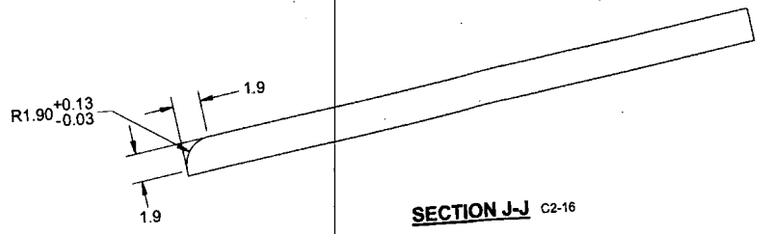
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☐ Turning Sequence
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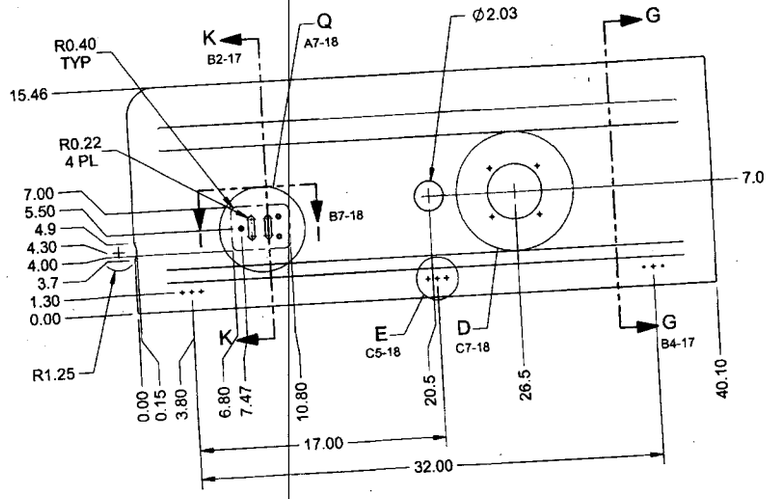
General

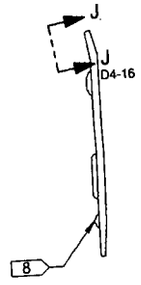
☐ Bend
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☐ Weld
☐ Wrong Stock Pulled
☐ Other



SECTION J-J C2-16

112086 MD
14-01-29





RELEASED
DATE 2014-01-22
MD

D4635-4 RH, AFT CEILING PANEL

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-4 PER TOOL DT9842
10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	REV. E
CHECKED	SC	DRAWING NO. D4635 SHEET 16 OF 18
MFG. APPR.		SCALE NTS
APPROVED		TITLE OUTBOARD CEILING PANELS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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☐ Other

DART AEROSPACE LTD

Description:	AFT Ceiling Panel RH	**Work Order:**	112086
Inspection Drawing:	4635-4	**Rev:** B	**Part Number:** D4635-4

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00	+/- 0.030	7.00	✓		tape	SFAB-21
3.80	+/- 0.030	3.83	✓			
7.47	+/- 0.030	7.50	✓			
17.00	+/- 0.030	17.00	✓			
32.00	+/- 0.030	32.00	✓			
20.5	+/- 0.100	20.5	✓			
26.5	+/- 0.100	26.5	✓			
7.0	+/- 0.100	7.0	✓			
Ø 2.03	+0.002 -0.001	Ø 2.030	✓			
Ø 3.50	+0.002 -0.001	Ø 3.50	✓			
Ø 0.191	+0.005 -0.001	Ø 0.191	✓		tape	SFAB-21
3.300	+/- 0.010	3.300	✓		Vern	SFAB-08
1.650	+/- 0.010	1.650	✓		Vern	
1.650	+/- 0.010	1.650	✓			
3.300	+/- 0.010	3.300	✓			
1.300	+/- 0.010	1.300	✓			
0.650	+/- 0.010	0.650	✓			
Ø 0.129	+0.005 -0.001	Ø 0.129	✓			
1.61	+/- 0.030	1.61	✓			
0.43	+/- 0.030	0.43	✓			
1.38	+/- 0.030	1.38	✓			
Ø 0.196	+0.005 -0.001	Ø 0.196		✓	Vern	SFAB-08

Measured by: SAD **Date** 14/03/13	**Checked By:** DAS 16 9-89 **Date** 14/03/14	**QC inspector:** DAS 16 9-89 **Date** 14/03/14	**Engineering Approval** *(if necessary)*: **Date**